

# Work Order ID 50117

July 08, 2009 11:32:20 AM

Page 1

Item ID: D135-751-011  
Revision ID: C  
Item Name: Skidtube Installation

Accept

Setup Start

Stop

Start Date: 7/10/2009 Start Qty: 1.00  
Required Date: 7/31/2009 Req'd Qty: 1.00

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3507	Rev C								

100

0.00

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

09/07/17

110

0.00

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Determine square end of tube and deburr □ 2-Drill #30 pilot holes using DT8678. Do not open holes. □ 3- Deburr holes.

H 9-7-13 D

120

0.00

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

D H 9-7-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 50117**

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Start Date: 7/10/2009 Start Qty: 1.00

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Required Date: 7/31/2009 Req'd Qty: 1.00

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Fwd end of the tube using DT8185□2-Cut Aft end at VC using DT8185□3-Deburr ends□4-Drill Aft & Fwd Cap holes using DT8678□5-Locate DT8870 & Drill Ground wire hole on top of Tube.□6-Locate DT8870 with 3/16cleco in Ground wire hole, then Pilot Drill a								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

3E 09/07/14

27 50107/14 @10

f

3E 09/07/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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July 08, 2009 11:32:20 AM

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**Stop**

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**Customer:**

**Reference:**

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**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

0.00

0.00

QC  
Quality Control

## Memo

170	0.00
-----	------

0.00

Skidtubes  
Skidtubes

## Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507.  
and Detail "F" 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr  
and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI  
015 A/R 241 Sike Flex Batch: M111557

MI 11557  
EXP 10-01-31

180	QC10- Inspect visual per QSI004- ground welds	0.00
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0.00

QC  
Quality Control

## Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 50117**

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Rivet D3506-1/-3 as per Dwg D3507.								
200	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
210	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

BE 09/07/15

=&gt; 8 07/07/16

(4D)

f

BR 07-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



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<b>Start Date:</b>	7/10/2009	<b>Start Qty:</b>	1.00
<b>Required Date:</b>	7/31/2009	<b>Req'd Qty:</b>	1.00

**Cust Item ID:**  
**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run	Start
	Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
	Powder Coating	Memo START TIME: 10:45am 11:15am FINISH TIME: 3:20pm M112148 09-07-16 (X) JH							
230	QC3- Inspect Part Finish	0.00							
	QC	0.00							
	Quality Control	Memo => 8016717 (X) C							
240	HandFinishing	0.00							
	HandFinish	0.00							
	Hand Finishing	Memo Install Wearplate &Ground Wire inserts as per Dwg D3507. BK 09-07-17. (X)							

BR 0907-17. (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**Stop**

**Customer:**

**Stop**

[illegible]

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

July 08, 2009 11:32:20 AM

**Stop**

**Cust Item ID:**  
**Customer:**

**Reference:**

**Stop**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Qty	Qty	Number	Stamp
5	7	17	59

Packaging	Memo
Packaging	

290	QC4- 100% Inspect kits for completeness	0.00
QC	<b>Memo</b>	0.00
Quality Control		

09/05/17

300		0.00
	Packaging	

Packaging	Memo	0.00
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Packaging Identify and pack for shipping as per PPP D135-751-011 ☐ Location: ☐ PPP Rev: 13

9/7/17 ~~40~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D135-751-011  
Revision ID: C  
Item Name: Skidtube Installation

Accept

Setup Start

Stop

Start Date: 7/10/2009 Start Qty: 1.00  
Required Date: 7/31/2009 Req'd Qty: 1.00

Cust Item ID:  
Customer:


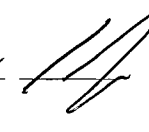
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/07/20  

u 09.07.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 1

July 08, 2009 11:32:19 AM

Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C4A		Purchased	No			120 290	Each	274.0000	8.0000		9/7/17	SY
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BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

274

112082

274

D2962-150RevA

Manufactured No

170

Each

49.0000

1.0000

112082

3.540 Outer Tube, Extrut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

49

28672

49

D3504-1RevC

Manufactured No

170

Each

31.0000

2.0000

① B 28672 M 9-7-15

Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

31

31234

31

2 BE 9-7-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

July 08, 2009 11:32:19 AM

Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3504-3RevC		Manufactured	No			170	Each	24.0000	1.0000			
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Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST 24

31232 24

D3504-5RevC		Manufactured	No			170	Each	26.0000	2.0000			
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Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST 26

36181 26

D3505-1RevA		Manufactured	No			170	Each	2.0000	1.0000			
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Web

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST 2

46541 2

July 08, 2009 11:32:19 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

July 08, 2009 11:32:19 AM

Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3506-1RevA      Manufactured      No      170      Each      6.0000      4.0000

Doubler

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

FG

46538

6

6

Each

8.0000

2.0000

27714

1

3

BE 09/07/16  
BE 09/07/15

D3506-3RevA

Manufactured      No

170

Each

8.0000

2.0000

Doubler

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

FG

8

28964

4

46539

4

Each

3,914.000

38.0000

2

BE 09/07/15

ALS7-1032-130

Purchased      No

240

Each

3,914.000

38.0000

Insert

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

ST

3914

108606

52

111529

1862

111779

2000

M110511

BE 09-07-17

July 08, 2009 11:32:19 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20601-AD4W3		Purchased	No			240	Each	354.0000	12.0000			
Rivet												
				<u>Warehouse</u>				<u>Loc Qty</u>			<u>Loc Code</u>	
				<u>Location</u>								
				Main Warehouse								
				ST				354				
				107823				54				
				111359				300				
ALS4-1032-225		Purchased	No			260	Each	9,205.000	1.0000			
Insert												
				<u>Warehouse</u>				<u>Loc Qty</u>			<u>Loc Code</u>	
				<u>Location</u>								
				Main Warehouse								
				ST				9205				
				107441				28				
				110768 ✓				9177				
AN3C4A		Purchased	No			260	Each	274.0000	31.0000			
BOLT												
				<u>Warehouse</u>				<u>Loc Qty</u>			<u>Loc Code</u>	
				<u>Location</u>								
				Main Warehouse								
				ST				274				
				112082 ✓				274				

1012 BE 07/07/15

1 BR 09-07-17.

31 BR 09-07-17.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN526C1032R10		Purchased	No			260	Each	604.0000	2.0000			
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Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	604	
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108062 ✓	145	
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108167	35	
--------	----	--

110049	424	
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AN960C10L		Purchased	No			260	Each	4,998.000	33.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--

washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	4998	
----	------	--

103585 ✓	100	
----------	-----	--

112116 ✓	4898	
----------	------	--

D2965-3RevB		Manufactured	No			260	Each	6.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	6	
----	---	--

46582 ✓	6	
---------	---	--

2 BR 09-07-17

33 BR 09-07-17.

1 BR 09-07-17.

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2965RevB		Manufactured	No			260	Each	29.0000	1.0000			

\* Cap, 105 Skidtube

Warehouse Loc Qty Loc Code  
Location

Main Warehouse *M50609*  
ST 29  
43288 6  
46800 23

D3492-041RevC Manufactured No

260 Each 27.0000 4.0000

*45861*

*4 BR 09-07-17.*

Plug Assembly

Warehouse Loc Qty Loc Code  
Location

Main Warehouse  
ST 27  
43816 19  
45561 ✓ 8

D3492-043RevC Manufactured No

260 Each 0.0000 4.0000

*M 46407.*

*4 BR 09-07-17.*

Plug Assembly

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 7

July 08, 2009 11:32:19 AM

Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

* D3492-047RevC		Manufactured	No			260	Each	66.0000	2.0000			
-----------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Plug Assembly

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	66	
----	----	--

27776	3	
-------	---	--

28961 ✓	45	
---------	----	--

39722	18	
-------	----	--

2 BR 09-07-17

D3508-1RevC		Manufactured	No			260	Each	6.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Wearplate

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	6	
----	---	--

42973 ✓	6	
---------	---	--

1 BR 09-07-17

D3508-3RevC		Manufactured	No			260	Each	7.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Wearplate

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	7	
----	---	--

42250	1	
-------	---	--

46881 ✓	6	
---------	---	--

1 BR 09-07-17

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 8

July 08, 2009 11:32:19 AM

Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3508-5RevC		Manufactured	No			260	Each	5.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Wearplate

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

42251 ✓

5

5

D3508-7RevC		Manufactured	No			260	Each	9.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Wearplate

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

44518 ✓

9

9

D3558-1RevB		Manufactured	No			260	Each	4.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Gasket

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

42533 ✓

4

4

1 BR 09-07-17.

1 BR 09-07-17

1 BR 09-07-17.

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3558-3RevB		Manufactured	No			260	Each	12.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

12

45661 ✓

12

D3558-5RevB		Manufactured	No			260	Each	5.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

5

43244 ✓

5

D3558-7RevB		Manufactured	No			260	Each	11.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

11

36388

4

43245 ✓

7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1611-007		Purchased	No			260	Each	448.0000	1.0000			
-------------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

O-RING

↑ either O-ring

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

448

103697

448

NAS1611-010		Purchased	No			260	Each	362.0000	1.0000			
-------------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

O-RING

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

362

110715

67

110915

295

NAS1611-013		Purchased	No			260	Each	330.0000	1.0000			
-------------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

O-RING

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

330

106513

11

111424 ✓

119

111758

200

SEE PTO

4 Bk of 07-17.

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W/O: 50117		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-16	200 PS10	used D2574-3 B25908	[Signature]	07-16		[Signature] 15/07/17	[Signature] 15/07/17	

Part No: D135-751-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 8		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 11

July 08, 2009 11:32:19 AM

Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C5A		Purchased	No			290	Each	546.0000	2.0000			
--------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

Bolt

9/7/17 SK

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

546

111424

8

111707 ✓

538

290

Each

7,161.000 8.0000

111707

2 BR 09-07-17.

109 9/7/17 SK

AN960JD10L

Purchased

No

Washer

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

7245

101291

16

104885

153

105793

236

109632

1837

110985

5000

18235

3

Main Warehouse

ST182

-84

109632

-84

209632

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 12

July 08, 2009 11:32:19 AM

Work Order ID: 50117

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3512-1RevC		Manufactured	No			290 ✓	Each	5.0000	2.0000			
-------------	--	--------------	----	--	--	-------	------	--------	--------	--	--	--

S Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

44642

5

44642

9/7/17

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

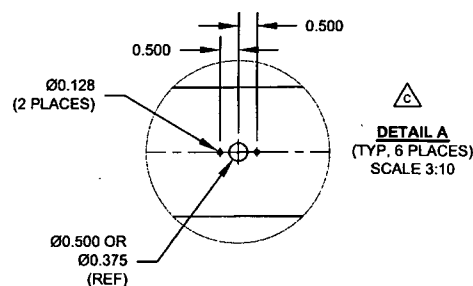
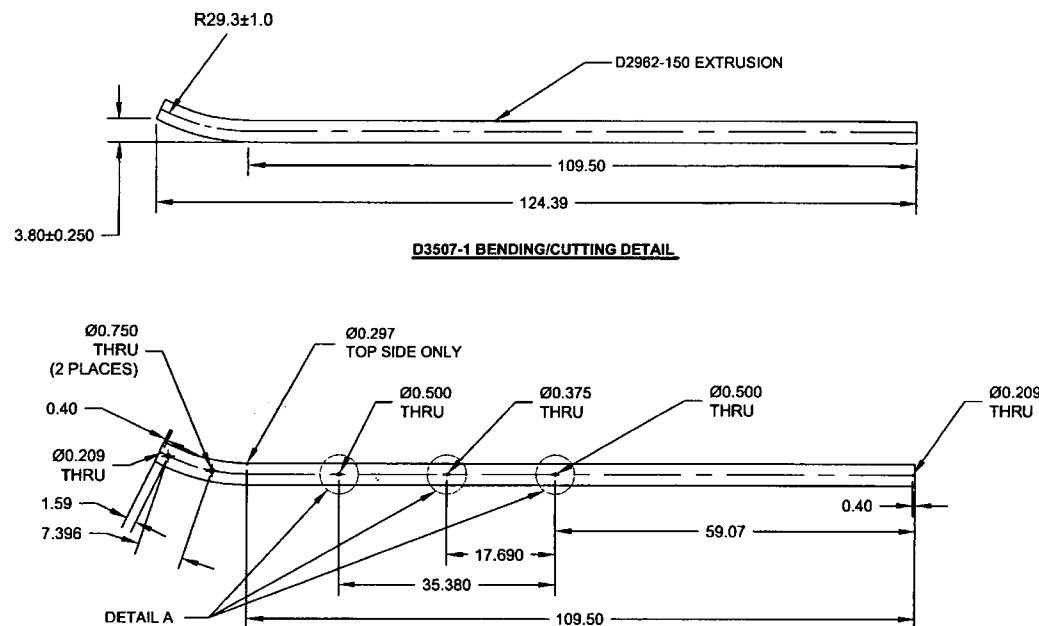


Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

#### GENERAL NOTES:

- 1) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JTC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.09.19		
<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA REV. C SHEET 1 OF 2 SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE SUPPLIER'S CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



50117

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 179

**AWS D17.1.2001**  
**QUALIFICATION TEST RECORD**

Name: Barclay Elliot  
Job number: 841333  
Part number: 135 751011  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum.  
Current: AC[☒] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks: pass[ ] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[ ] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

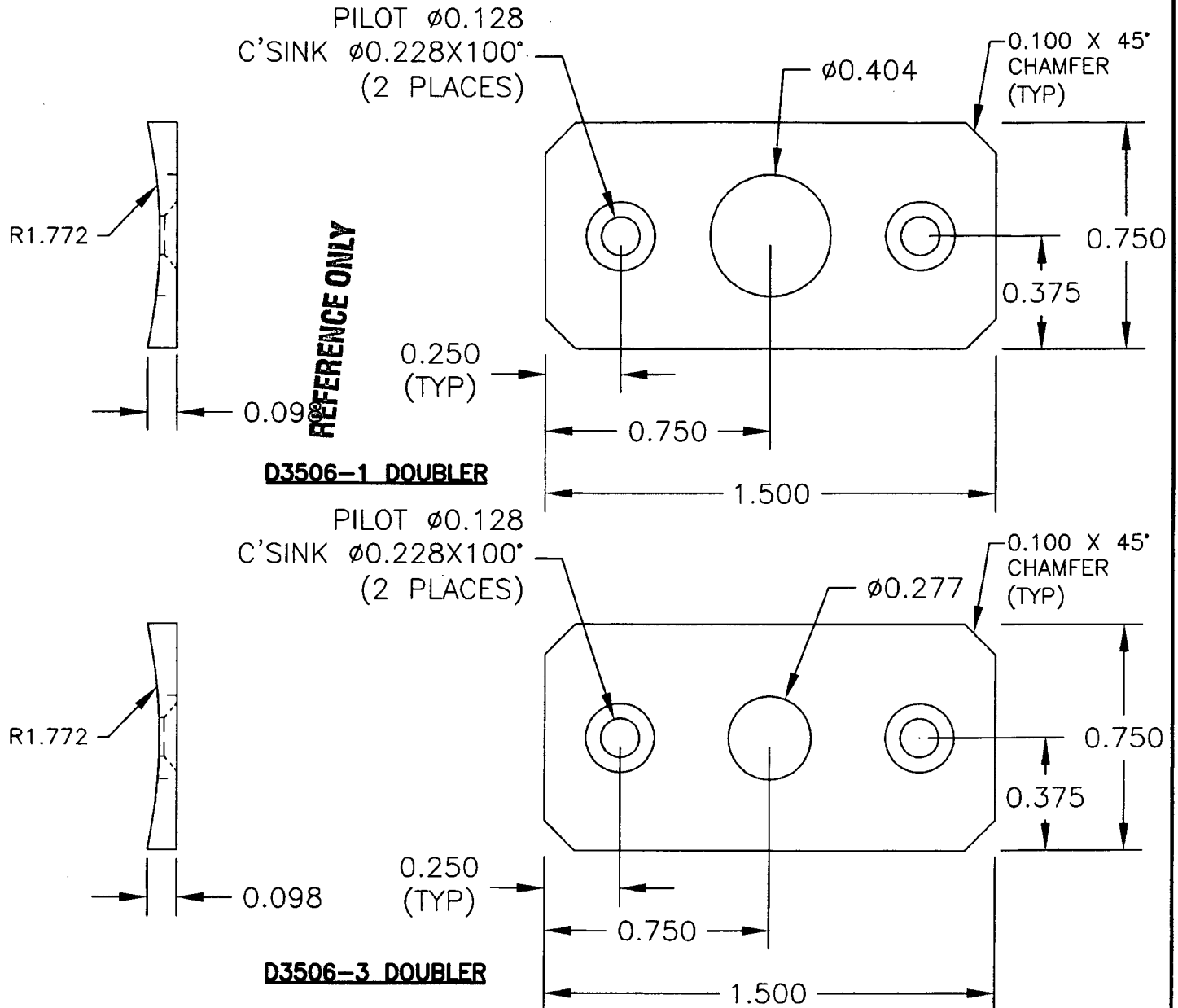
Qualifier David Lund Date of Test Coupon 08/10/22

Welder Barclay Elliot Date of Test Coupon 08/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

**DART**

DESIGN 471	DRAWN BY 471	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 471	APPROVED 471	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	

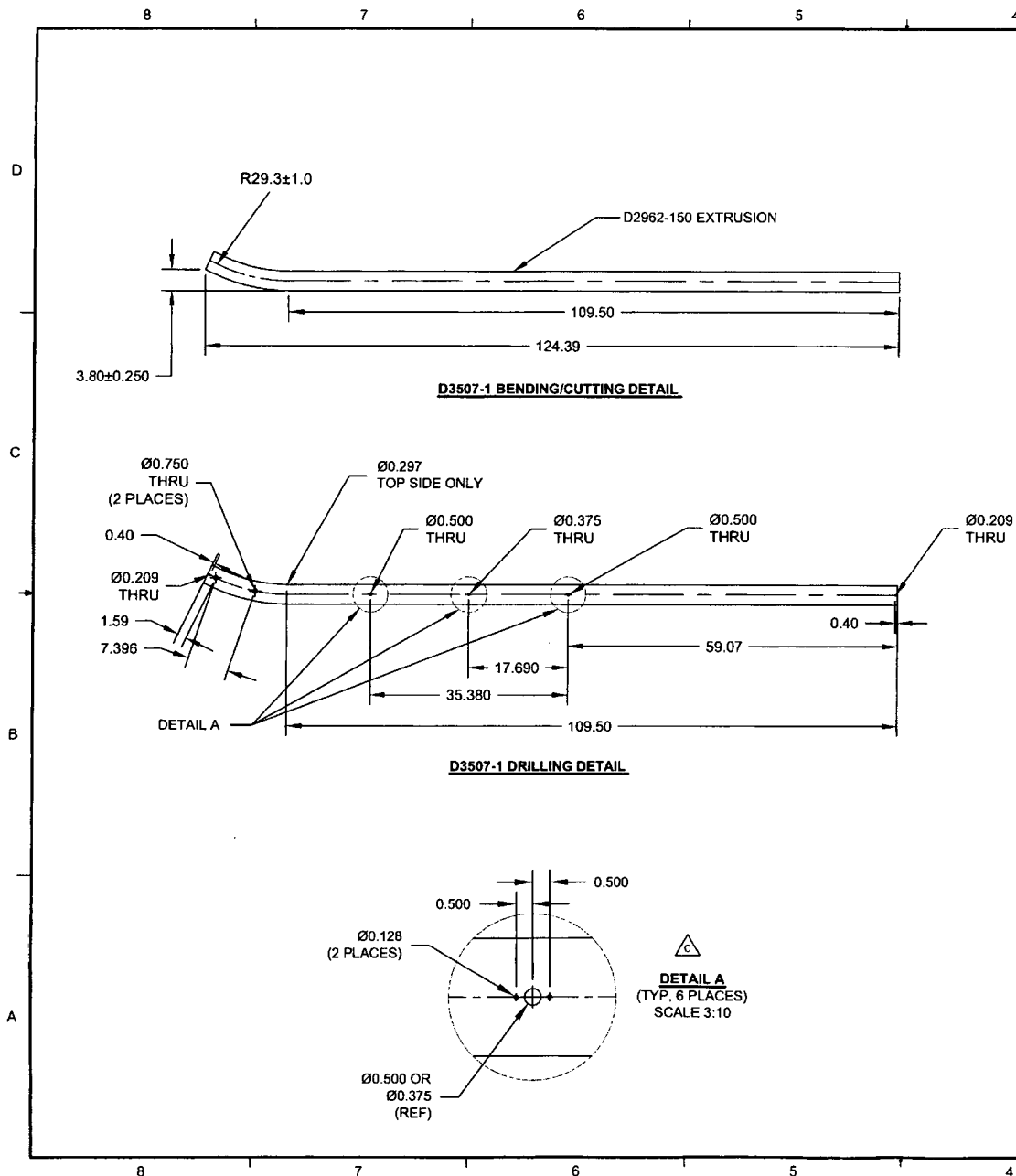
**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)  
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**  
06.10.03 PM  
PER EUN #851

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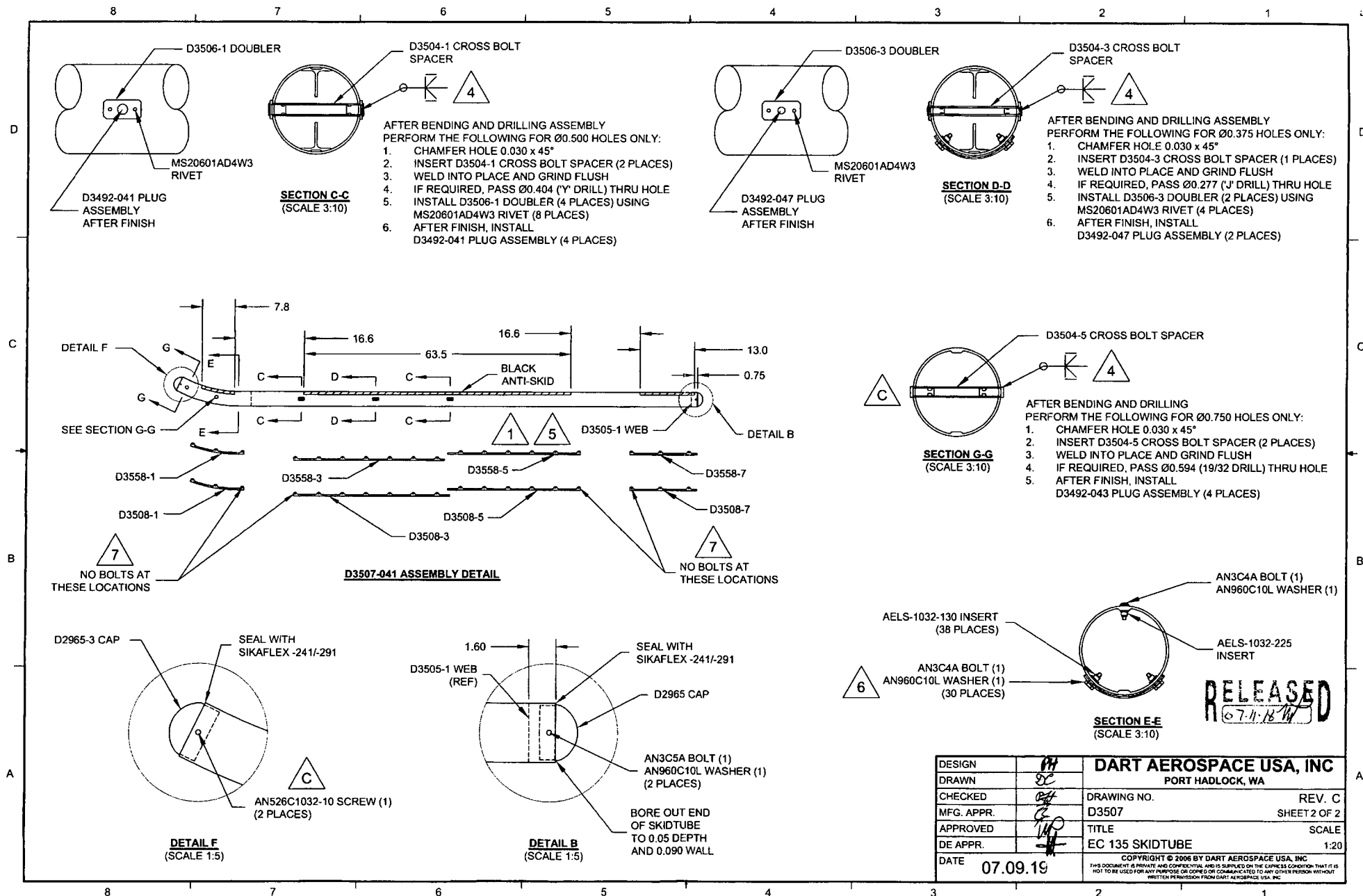
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

#### GENERAL NOTES:

- FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JTC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.09.19		
<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA DRAWING NO. D3507 TITLE EC 135 SKIDTUBE REV. C SHEET 1 OF 2 SCALE NTS <small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

RELEASED  
07.11.16





Date: Wednesday, 7/15/09 2:23:02 PM

User: Linda Lacelle

## JOB HISTORY : DETAIL

Goes w/ B/N

<b>Job Number</b>	: 27809	<b>Customer</b>	: Dart Helicopters Services
<b>Estimate Number</b>	: 12472	<b>DWG Name</b>	: EC 135 SKIDTUBE ASSEMBLY
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D135751011
<b>Complete Date</b>	: 8/24/06 1:41:22 PM	<b>DWG Number</b>	: D3507 PRELIMINARY
		<b>Rev.</b>	: PREL

<b>12.0 D35061-Doubler INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	D35061	8.000		\$196.44		Lot # 27714 Qty. 8
<b>Subtotal:</b> QTD: 8 CTD: 0 \$196.44							

<b>13.0 D35063-Doubler INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	D35063	4.000		\$265.68		Lot # 27715 Qty. 4
<b>Subtotal:</b> QTD: 4 CTD: 0 \$265.68							

<b>14.0 MS20601AD4W3-Rivet INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	MS20601AD4W3	24.000		\$4.08		Lot # 8325 Qty. 24
<b>Subtotal:</b> QTD: 24 CTD: 0 \$4.08							

<b>15.0 SKIDTUBES 1 Internal Operation</b>							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
7/27/06	ELLI01: Elliott, Barclay	Run	2.000	0.82	\$15.51	0.82	16.40
7/28/06	ELLI01: Elliott, Barclay	Run	2.000	1.94	\$36.70	1.94	38.80
7/31/06	ELLI01: Elliott, Barclay	Run	2.000	0.48	\$9.08	0.48	9.60
8/01/06	MCPH01: McPherson, Patrick	Run	1.000	0.24	\$3.43	0.24	4.80
8/01/06	ELLI01: Elliott, Barclay	Run	2.000	3.52	\$66.60	3.52	70.40
<b>Subtotal:</b> QTD: 9 CTD: 0 7.00 \$271.32							

<b>17.0 POWDER COATING Internal Operation</b>							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
8/08/06	MYRE01: Myre, Alexandre	Run	2.000	0.93	\$12.38	0.94	68.62
<b>Subtotal:</b> QTD: 2 CTD: 0 0.93 \$81.00							

<b>18.0 HAND FINISHING1 Internal Operation</b>							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
8/09/06	LALI01: Laliberte, Daniel	Run	0.000	0.86	\$12.30	0.86	17.20
8/09/06	LALI01: Laliberte, Daniel	Run	0.000	0.25	\$3.58	0.25	5.00
<b>Subtotal:</b> QTD: 0 CTD: 0 1.11 \$38.08							

<b>20.0 ALS41032130-Insert INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	ALS41032130	76.000		\$9.11		Lot # 18293 Qty. 76
<b>Subtotal:</b> QTD: 0 CTD: 76 \$9.11							

<b>21.0 ALS41032225-Insert INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	ALS41032225	2.000		\$0.39		Lot # 19393 Qty. 2
<b>Subtotal:</b> QTD: 2 CTD: 0 \$0.39							

Date: Wednesday, 7/15/09 2:23:03 PM

User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 27809	<b>Customer</b>	: Dart Helicopters Services
<b>Estimate Number</b>	: 12472	<b>DWG Name</b>	: EC 135 SKIDTUBE ASSEMBLY
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D135751011
<b>Complete Date</b>	: 8/24/06 1:41:22 PM	<b>DWG Number</b>	: D3507 PRELIMINARY
		<b>Rev.</b>	: PREL

<b>22.0 HAND FINISHING1 Internal Operation</b>							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
8/08/06	LALI01: Laliberte, Daniel	Run	1.000	0.59	\$8.44	0.59	11.80
<b>Subtotal:</b>			QTD: 1	CTD: 0	0.59	\$20.24	

<b>24.0 D2965-Cap, 105 Skidtube INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	D2965	4.000		\$66.68		Lot # 19772 Qty. 4
<b>Subtotal:</b>			QTD: 4	CTD: 0	\$66.68		

<b>25.0 D35081-Wearplate INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	D35081	2.000		\$936.80		Lot # 27710 Qty. 2
<b>Subtotal:</b>			QTD: 2	CTD: 0	\$936.80		

<b>26.0 D35083-Wearplate INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	D35083	2.000		\$779.32		Lot # 27711 Qty. 2
<b>Subtotal:</b>			QTD: 2	CTD: 0	\$779.32		

<b>27.0 D35085-Wearplate INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	D35085	2.000		\$434.93		Lot # 27712 Qty. 2
<b>Subtotal:</b>			QTD: 2	CTD: 0	\$434.93		

<b>28.0 D35087-Wearplate INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	D35087	2.000		\$497.60		Lot # 27713 Qty. 2
<b>Subtotal:</b>			QTD: 2	CTD: 0	\$497.60		

<b>29.0 D3492041-Plug Assembly INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	D3492041	8.000		\$46.52		Lot # 26304 Qty. 8
<b>Subtotal:</b>			QTD: 8	CTD: 0	\$46.52		

<b>30.0 D3492047-Plug Assembly INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	D3492047	4.000		\$130.70		Lot # 27776 Qty. 4
<b>Subtotal:</b>			QTD: 4	CTD: 0	\$130.70		

<b>31.0 MS27039108-Screw INVENTORY ITEM</b>							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/24/06	LACE01: Lacelle, Linda	MS27039108	16.000		\$1.24		Lot # 100854 Qty. 16
<b>Subtotal:</b>			QTD: 0	CTD: 16	\$1.24		

Date: Wednesday, 7/15/09 2:23:03 PM  
 User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b> : 27809		<b>Customer</b> : Dart Helicopters Services	
<b>Estimate Number</b> : 12472		<b>DWG Name</b> : EC 135 SKIDTUBE ASSEMBLY	
<b>Purchase Order #</b> :		<b>Part Number</b> : D135751011	
<b>Complete Date</b> : 8/24/06 1:41:22 PM		<b>DWG Number</b> : D3507 PRELIMINARY	<b>Rev.</b> : PREL
<b>32.0 AN960JD10L-Washer INVENTORY ITEM</b>			
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
8/24/06	LACE01: Lacelle, Linda	AN960JD10L	16.000
		<b>COST</b>	Lot # 101291 Qty. 16
<b>Subtotal:</b>		QTD: 0 CTD: 16	\$0.41
<b>33.0 AN960JD10L-Washer INVENTORY ITEM</b>			
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
8/24/06	LACE01: Lacelle, Linda	AN960JD10L	70.000
		<b>COST</b>	Lot # 100233 Qty. 70
<b>Subtotal:</b>		QTD: 70 CTD: 0	\$1.81
<b>34.0 MS27039108-Screw INVENTORY ITEM</b>			
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
8/24/06	LACE01: Lacelle, Linda	MS27039108	48.000
		<b>COST</b>	Lot # 19551 Qty. 48
<b>Subtotal:</b>		QTD: 48 CTD: 0	\$3.73
<b>35.0 MS27039109-Screw INVENTORY ITEM</b>			
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
8/24/06	LACE01: Lacelle, Linda	MS27039109	8.000
		<b>COST</b>	Lot # 8912 Qty. 8
<b>Subtotal:</b>		QTD: 8 CTD: 0	\$0.69
<b>36.0 HAND FINISHING1 Internal Operation</b>			
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
8/08/06	MYRE01: Myre, Alexandre	Run	1.000
8/08/06	LALI01: Laliberte, Daniel	Run	2.000
8/09/06	MYRE01: Myre, Alexandre	Run	0.000
		<b>Time(hrs)</b>	<b>COST</b>
		<b>MTime(hrs)</b>	<b>Mach.Cost</b>
		1.35	\$17.97
		2.54	\$36.32
		0.81	\$10.78
		1.35	27.00
		2.54	50.80
		0.81	16.20
<b>Subtotal:</b>		QTD: 3 CTD: 0	4.70 \$159.07
<b>38.0 PACKAGING 1 Internal Operation</b>			
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
8/10/06	PROV02: Provencal, Aileen	Run	2.000
		<b>Time(hrs)</b>	<b>COST</b>
		<b>MTime(hrs)</b>	<b>Mach.Cost</b>
		0.14	\$2.15
		0.14	2.80
<b>Subtotal:</b>		QTD: 2 CTD: 0	0.14 \$4.95
<b>39.0 D35121-Wearplate INVENTORY ITEM</b>			
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
8/24/06	LACE01: Lacelle, Linda	D35121	4.000
		<b>COST</b>	Lot # 27716 Qty. 4
<b>Subtotal:</b>		QTD: 4 CTD: 0	\$1004.11
		<b>TIME</b>	<b>COST</b>
		<b>Machine Time:</b>	22.61 \$550.39
		<b>Labor:</b>	22.60 \$382.59
		<b>Sub-contract (external Op.):</b>	\$0.00
		<b>INVENTORY ITEM:</b>	\$4699.45
		<b>SUB-COMPONENT (SUB-JOB):</b>	\$0.00
<b>Total:</b>			\$5632.43
		<b>COST PER UNIT:</b>	\$2816.21

Date: Wednesday, 7/15/09 2:23:02 PM

User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 27809	<b>Customer</b>	: Dart Helicopters Services
<b>Estimate Number</b>	: 12472	<b>DWG Name</b>	: EC 135 SKIDTUBE ASSEMBLY
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D135751011
<b>Complete Date</b>	: 8/24/06 1:41:22 PM	<b>DWG Number</b>	: D3507 PRELIMINARY
		<b>Rev.</b>	: PREL

<b>DUE DATE</b>	<b>ORDERED</b>	<b>DELIVERED</b>
8/04/06	2	2

<b>2.0 D2962150-3.540 Outer Tube, Extrut</b>	<b>INVENTORY ITEM</b>
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DATE	EMPLOYEE	TYPE	Qty		COST	
8/24/06	LACE01: Lacelle, Linda	D2962150	2.000		\$62.02	Lot # 27774 Qty. 2
<b>Subtotal:</b>	QTD:	2 CTD:	0		\$62.02	

<b>3.0 SKIDTUBES 1</b>	<b>Internal Operation</b>
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
7/06/06	PAQU03: Paquette, Dan	Run	2.000	0.09	\$1.70	0.09	0.00
7/26/06	MCPH01: McPherson, Patrick	Run	1.000	0.50	\$7.16	0.50	10.00
<b>Subtotal:</b>	QTD:	3 CTD:	0	0.59	\$18.86		

<b>4.0 BENDING</b>	<b>Internal Operation</b>
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
7/06/06	PAQU03: Paquette, Dan	Run	1.000	1.13	\$21.37	1.13	66.67
7/26/06	MCPH01: McPherson, Patrick	Setup	1.000	0.50	\$7.16	0.50	29.50
7/26/06	MCPH01: McPherson, Patrick	Run	1.000	0.40	\$5.72	0.40	23.60
<b>Subtotal:</b>	QTD:	3 CTD:	0	2.03	\$154.02		

<b>5.0 SKIDTUBES 1</b>	<b>Internal Operation</b>
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
7/06/06	PAQU03: Paquette, Dan	Run	1.000	1.45	\$27.42	1.45	0.00
7/26/06	ELLI01: Elliott, Barclay	Run	2.000	3.50	\$66.22	3.50	70.00
<b>Subtotal:</b>	QTD:	3 CTD:	0	4.95	\$163.64		

<b>7.0 HAND FINISHING1</b>	<b>Internal Operation</b>
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
7/27/06	ELLI01: Elliott, Barclay	Run	2.000	0.56	\$10.60	0.56	11.20
<b>Subtotal:</b>	QTD:	2 CTD:	0	0.56	\$21.80		

<b>9.0 D35043-Crossbolt Spacer</b>	<b>INVENTORY ITEM</b>
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DATE	EMPLOYEE	TYPE	Qty		COST	
8/24/06	LACE01: Lacelle, Linda	D35043	4.000		\$44.13	Lot # 28034 Qty. 4
<b>Subtotal:</b>	QTD:	4 CTD:	0		\$44.13	

<b>10.0 D35041-Crossbolt Spacer</b>	<b>INVENTORY ITEM</b>
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DATE	EMPLOYEE	TYPE	Qty		COST	
8/24/06	LACE01: Lacelle, Linda	D35041	4.000		\$52.62	Lot # 28033 Qty. 4
<b>Subtotal:</b>	QTD:	4 CTD:	0		\$52.62	

<b>11.0 D35051-Web</b>	<b>INVENTORY ITEM</b>
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DATE	EMPLOYEE	TYPE	Qty		COST	
8/24/06	LACE01: Lacelle, Linda	D35051	2.000		\$160.44	Lot # 27811 Qty. 2
<b>Subtotal:</b>	QTD:	2 CTD:	0		\$160.44	